



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D212-664-201
Job Sheet 183770



Part No: D212-664-201

Job Qty: 1 ea

Part Name: Aft Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D212-664 REV.J/ D212-664-241 REV E IPP Rev:E 04.02.16 Reformat K/DS IPP Rev:F 06-03-29 Remove
Coments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 08-05-22 up date Qty of rubber
cushion DD verf:EC IPP REV:I 14.05.27 AS PER ECN14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Crosstubes-1		GP 2018-10-25
110	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging1-3		GP 2018-10-25
120	CNC Bend Crosstubes	1 pcs	10/26/18	10/26/18	0.00	4.44	CNC Bend Crosstube		GP 2018-10-25
130	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC15		38
140	Crosstubes	1 pcs	10/26/18	10/26/18	0.00	4.99	Crosstubes-1		GP 2018-10-25
150	HandFXtube	1 pcs	10/26/18	10/26/18	0.00	1.25	HandFinish5		GP 2018-10-25
160	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC7-1		21/17-15/10/15
170	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		11
180	Outsource	1 pcs	10/26/18	10/26/18			SKY002-VC	5	GP 15-10-27
190	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging2		OCT 30 2018
200	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		38
210	SprayPaint	1 pcs	10/26/18	10/26/18	0.00	1.47	Spray Paint		GP 18-10-27
220	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC14		AB 18-11-5
230	Crosstubes	1 pcs	10/26/18	10/26/18	0.00	1.47	Crosstube		AB 18-11-5
240	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging1-3		NOV 08 2018
260	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC4		21
270	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-1		NOV 08 2018
275	DC	1 pcs	10/26/18	10/26/18	0.00	0.00	DC		21
280	QC21-FG	1 Ea	10/26/18	10/26/18	0.00	0.00	QC21		21

Part Op 120 - ***VERF SET-UP BEFORE BENDING BY: *** Bend tube as per Dwg D212-664-241 using
Descriptions: CNC bender program 212-aft

140 - 1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550, DT8551, drill table DT8577 and locate tower holes #8 as per QSI0010. 2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241 4- ***WEAR LATEX GLOVES HANDLING CROSSTUBE.*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

150 - ***IMMEDIATELY AFTER GRINDING***

180 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O 041475 LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2

190 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.***

200 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Inspect for damage & ensure results are as per Dwg D212-664-241

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

220 - Then, Wrap in plastic bag to protect from scratches

230 - *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-241 and QSI 015 A/R Proseal 890 Batch: 5096394 EXP: 3/19
PROSEAL CURE TIME 72 HOURS: Start: 18-11-5 Finish: 18-11-8 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-241. ***Torque all clamps to 80-100 IN-LBS.***

240 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

270 - Identify and pack for shipping as per PPP D212-664-201 Location : FG098

275 - Photocopy bluefile and create labels as per PPP D212-664-201 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-201TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	<u>5118819</u>
D2940-1	Support	2 Ea (2 ea)	230-Crosstubes	
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 Ea (4 ea)	230-Crosstubes	
MS21920-28	Clamp	4 Ea (4 ea)	230-Crosstubes	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	250-Packaging	<u>5041188</u>
AN6-41A	Bolt	2 Ea (2 ea)	250-Packaging	<u>5045844</u>
D3428-1	Placard	1 Ea (1 ea)	250-Packaging	<u>5059483</u>
MS21042L6	Nut	6 Ea (6 ea)	250-Packaging	<u>5009002</u>
NAS1149D0663J	Washer	18 Ea (18 ea)	250-Packaging	<u>5093765</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-201TRN	1	0	0
230-Crosstubes	D2940-1 <u>5124354</u>	<u>2</u>	5	0
	D3595-063-530 <u>5080001</u>	<u>4</u>	57	0
	MS21920-28 <u>5100402</u>	<u>4</u> <u>50812370</u>	88	0
250-Packaging	AN6-40A	4	111	0
	AN6-41A	2	45	0
	D3428-1	1	49	0
	MS21042L6	6	410	0
	NAS1149D0663J	18	1,246	0

Part Specifications

Specifications could not be found.

9:46 AM Dart.lajeunesse.marie

DART AEROSPACE LTD.
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CANADA
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Email: sales@dartero.com
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DART
AEROSPACE

Container No: S121675

Part: D212-664-201

Job No: 183770

Serial No/Batch: S121675

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3 per A00876 SR01298NY 09/01/08, EASA STI

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

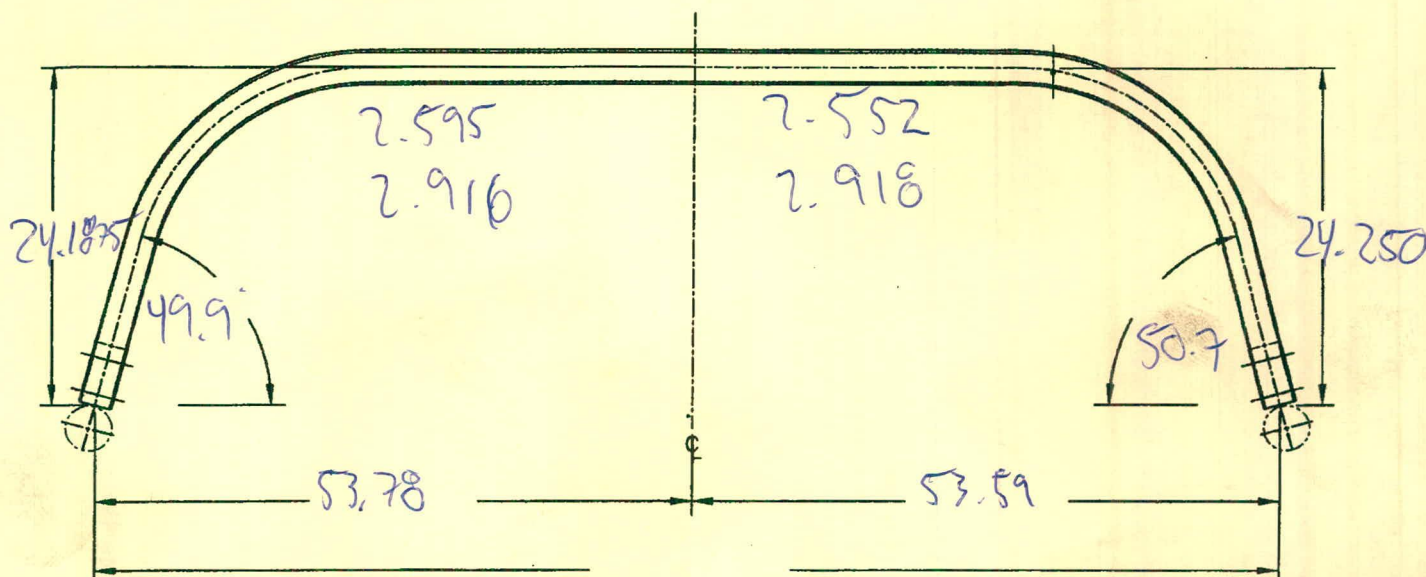
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																						OTHER : _____																																									

DART AEROSPACE LTD	Work Order: 183770
Description: Crosstube High Aft (205/212)	Part Number: D212-664-201
Inspection Dwg: D212-664-241 Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70
Bending Passes	5	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	19	21
Crushing	5.8%	6.7%
Comments		

QC15 Inspection	273
Date	18-10-25

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.08	Crushing percentage revised	KJ	4

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2		D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6		2	D5018-1	SUPPORT
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241/-241B = 44.2 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- INSTALL D2940-1 / D5018-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 183770 *18-09-26*

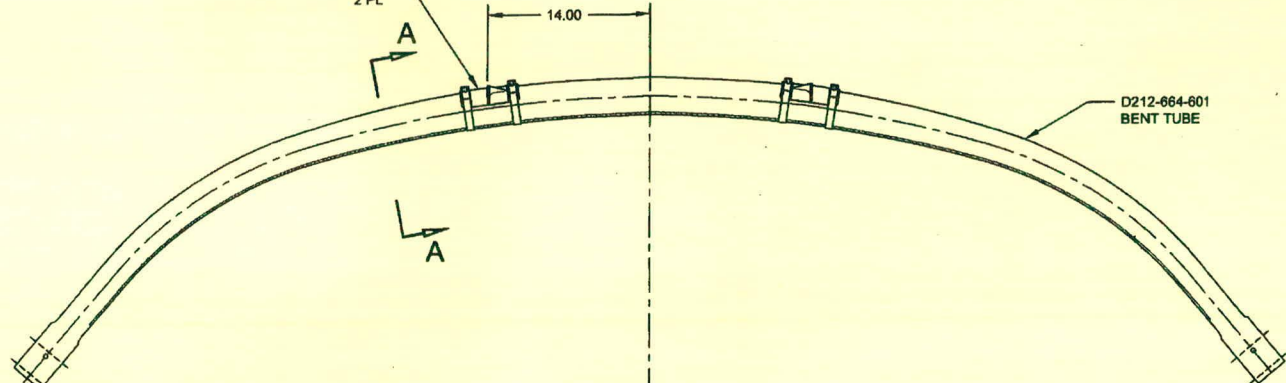
RELEASED
2014-05-26

E	D5018-1 WAS D2940-1 (-241B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (ZN B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-4), INCORP DEO D-1/-2	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST: REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 8398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-241	REV. E SHEET 1 OF 5
TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
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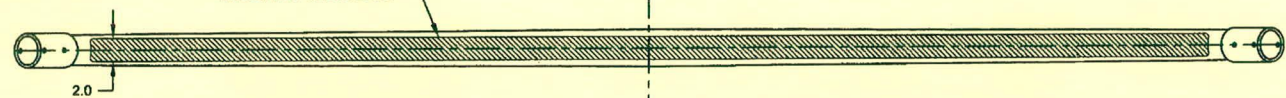
8 7 6 5 4 3 2 1

13 14 15
D2940-1 SUPPORT
MS21920-28 CLAMP, 2X
D3595-063-530 RUBBER CUSHION, 2X
2 PL



D212-664-601
BENT TUBE

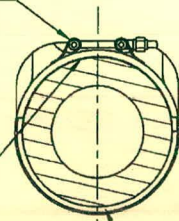
MASK AREA PRIOR TO PAINTING,
REMOVE MASKING AFTER PAINT
AND APPLY CLEAR COAT



D212-664-241
ASSEMBLY DETAIL

E MS21920-28
CLAMP, REF
14 15

E 13
APPLY PROSEAL
BETWEEN D2940-1 AND
CROSSTUBE



D2940-1
SUPPORT, REF

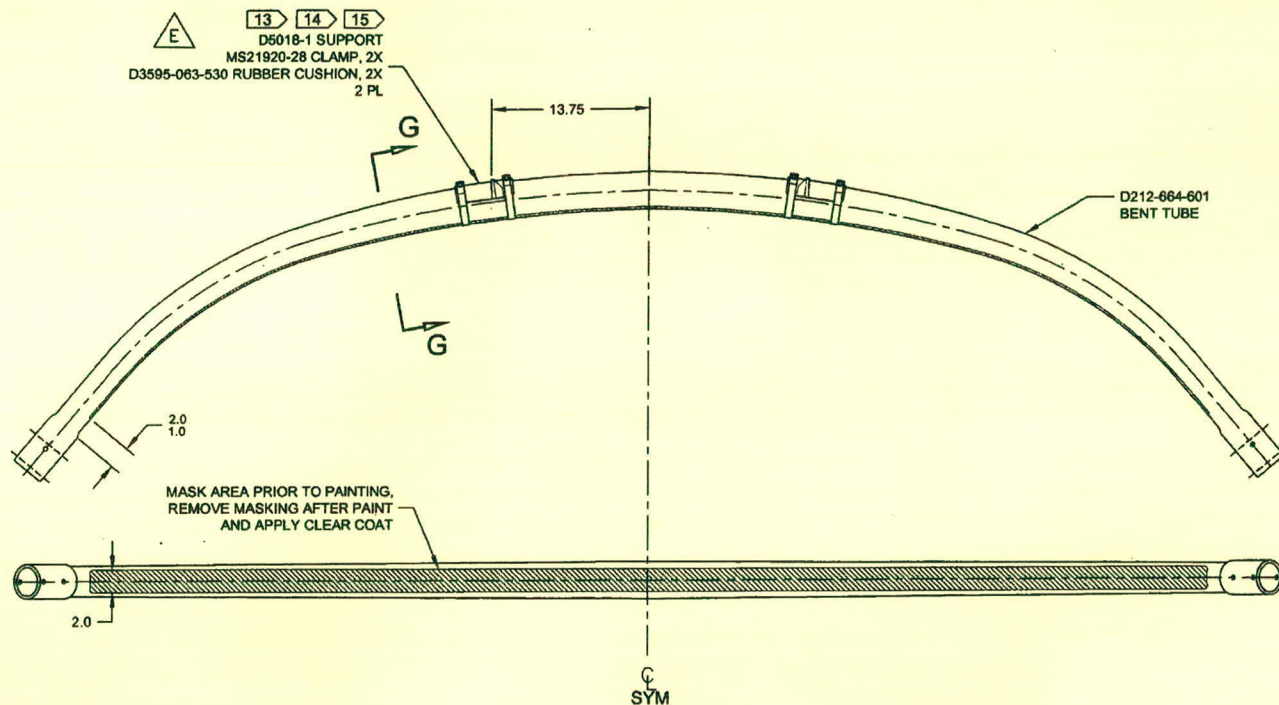
D3595-063-530 RUBBER CUSHION
UNDER CLAMP, REF

SECTION A-A
SCALE 4X

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2014-05-26
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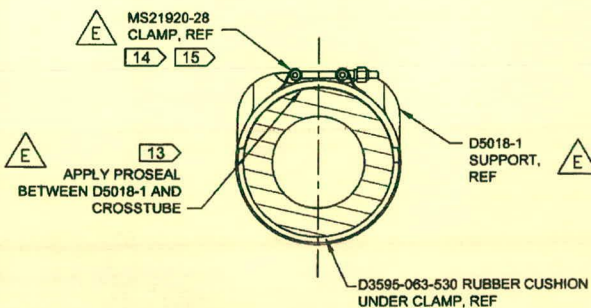
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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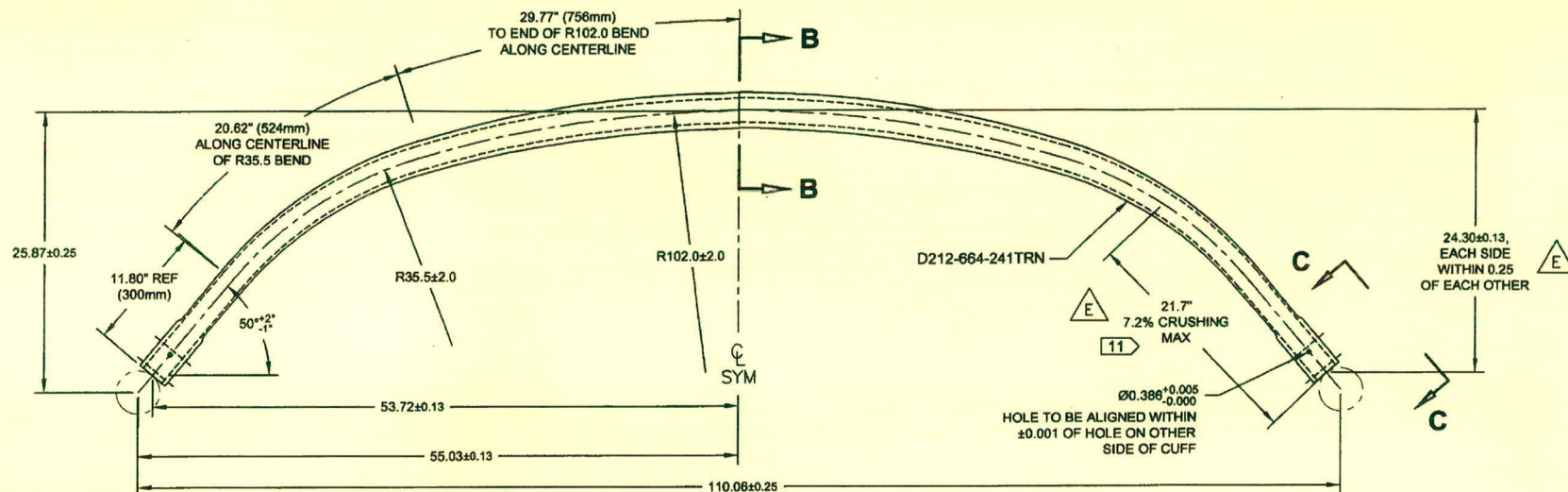
D212-664-241B
ASSEMBLY DETAIL

RELEASED
 2014-05-26

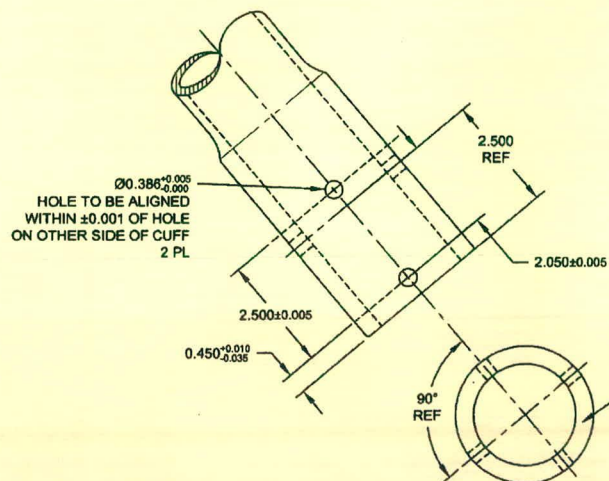


SECTION G-G
 SCALE 4X

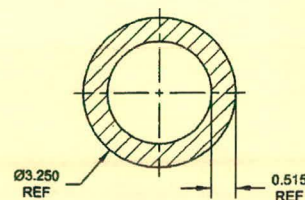
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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D212-664-601 11
BENDING AND DRILLING DETAIL



VIEW C-C: CUFF DETAIL
 SCALE 3X



SECTION B-B
 SCALE 4X

RELEASED
 2014-05-26
WMD

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DW</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D212-664-241	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041475**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041475
PO Date: 10/26/18
Due Date: 10/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184178	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$156.00/pcs	\$156.00
						OCT 30 2018					
2	184697	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00
						OCT 30 2018					
	184695			Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00
Sub Total:							2	0	2		\$150.00
3	183769	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$156.00/pcs	\$156.00
						OCT 30 2018					
	183770			Firmed	-	10/30/18	1 pcs	0 pcs	1 pcs	\$156.00/pcs	\$156.00



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PURCHASE ORDER **PO041475**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Sub Total:							2	0	2		\$312.00
4	184479	D350-748-101	FWD Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 Issue P/O: Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375 defree for 8 hrs, Chromate Treat C of C req'd ISSUE P/O TO SKYSERVICE:	Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
	184476			Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
	184478			Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
Sub Total:							3	0	3		\$368.18
5	184480	D350-748-201	Aft Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKYSERVICE:	Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
	184483			Firmed -		10/30/18	1 pcs	0 pcs	1 pcs	\$122.7272/pcs	\$122.73
Sub Total:							2	0	2		\$245.45
Grand Total:											\$1,231.64



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER PO041475

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/29/18 8:56 AM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37958	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041475
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

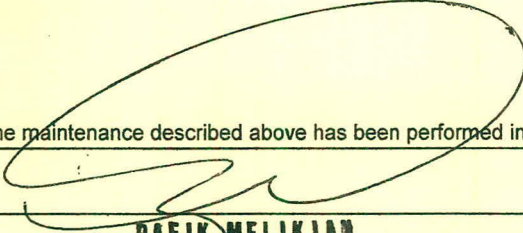
- 1 FUEL TANK ASSY , P/N# D4464-041 , J/S# 184178 ✓
- 2 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 184695 , 184697 ✓
- 2 AFT CROSSTUBES , P/N# D212-664-201 , J/S# 183770 , 183769 ✓
- 3 FWD CROSSTUBES , P/N# D350-748-101 , J/S# 184476 , 184478 , 184479 ✓
- 2 AFT CROSSTUBES , P/N# D350-748-201 , J/S# 184480 , 184483 ✓

Action Taken:	Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142	OCT 26 2018	 

DAS
38
9-89

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: OCT 26 2018
Name: RAFIK MELIKIAN		

